

APPENDIX D

Film Build Cpk's Cost Impact Analysis

1ST PREMISE

- VARIATION SELECTION**
- 1) Choose Variability
 - 2) Select First Target Range
 - 3) Average Adjusted to World Class Standard

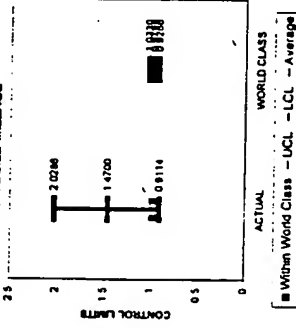
Coating: Taupe Prime
Point: 22
Booth: na

Coating Min. Spec.: 0.9
Actual Average: 1.47
Actual Range: 0.21
Actual Cpk: 1.04
Target Range: 0.02
World Class Cpk: 1.5

Effect on Coating Usage -33.35%

Approximate Annualized Cost Impact
\$ (1,418.12)

FILM BUILD MILLAGE



3RD PREMISE

- VARIATION REDUCTION**
- 1) Variability Adjusted to World Class Standard
 - 2) Coating Usage Remains Consistent
 - 3) Average Remains Constant

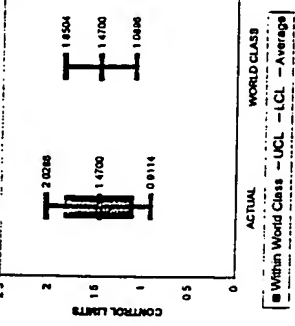
Coating: Taupe Prime
Point: 22
Booth: na

Coating Min. Spec.: 0.9
Actual Average: 1.47
Actual Range: 0.21
Actual Cpk: 1.04
New Range: 0.14
World Class Cpk: 1.5

Effect on Coating Usage 0.00%

Approximate Annualized Cost Impact
\$ nil

FILM BUILD MILLAGE



2ND PREMISE

- VARIATION SELECTION**
- 1) Choose Variability
 - 2) Select Second Target Range
 - 3) Average Adjusted to World Class Standard

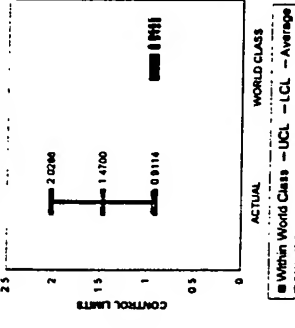
Coating: Taupe Prime
Point: 22
Booth: na

Coating Min. Spec.: 0.9
Actual Average: 1.47
Actual Range: 0.21
Actual Cpk: 1.04
Target Range: 0.01
World Class Cpk: 1.5

Effect on Coating Usage -39.96%

Approximate Annualized Cost Impact
\$ (1,531.57)

FILM BUILD MILLAGE



4TH PREMISE

- INCREASED MILLAGE**
- 1) Coating Usage Increases
 - 2) Variability Remains Constant
 - 3) Average Adjusted to World Class Standard

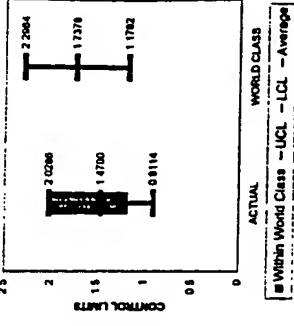
Coating: Taupe Prime
Point: 22
Booth: na

Coating Min. Spec.: 0.9
Actual Average: 1.47
Actual Range: 0.21
Actual Cpk: 1.04
New Average: 1.74
World Class Cpk: 1.5

Effect on Coating Usage 18.22%

Approximate Annualized Cost Impact
\$ 774.61

FILM BUILD MILLAGE



Cost per Unit Factors:				
Coating: Taupe Prime	Point: 22	Usage per Unit (gal.): 0.27	Cost per Gallon (\$): 30.00	Booth % Flow: 100
			Coating Popularity %: 25	Annualized Production (units): 200,000
			Point %: 1.05	

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